

Work Order ID 109973

109973

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December-11-13 8:36:24 AM

Item ID: D2739

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 350 I Beam

Start Date: 12/11/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/13/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

0.00

100

100

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

DC 13/12/11

0.00

120

120

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

DC 13/12/11

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Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 12/11/13 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 12/13/13 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						13-12-11	
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>L/C</u> Memo	0.00 0.00						De 13/12/11	(10)
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						Rm 13/12/18	

13-12-18

Picklist Print

December-11-13 8:36:23 AM

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Work Order ID: 109973

Parent Item: D2739

Parent Item Name: 350 I Beam

Start Date: 12/11/13

Required Date: 12/13/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F 10.11.02 as per revE

DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured No

Each 104.0000

Extrusion I Beam' thin

DL 13¹⁰/12/11

Location

Loc Qty

Loc Code

HALL

104

105417

78

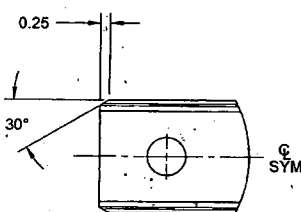
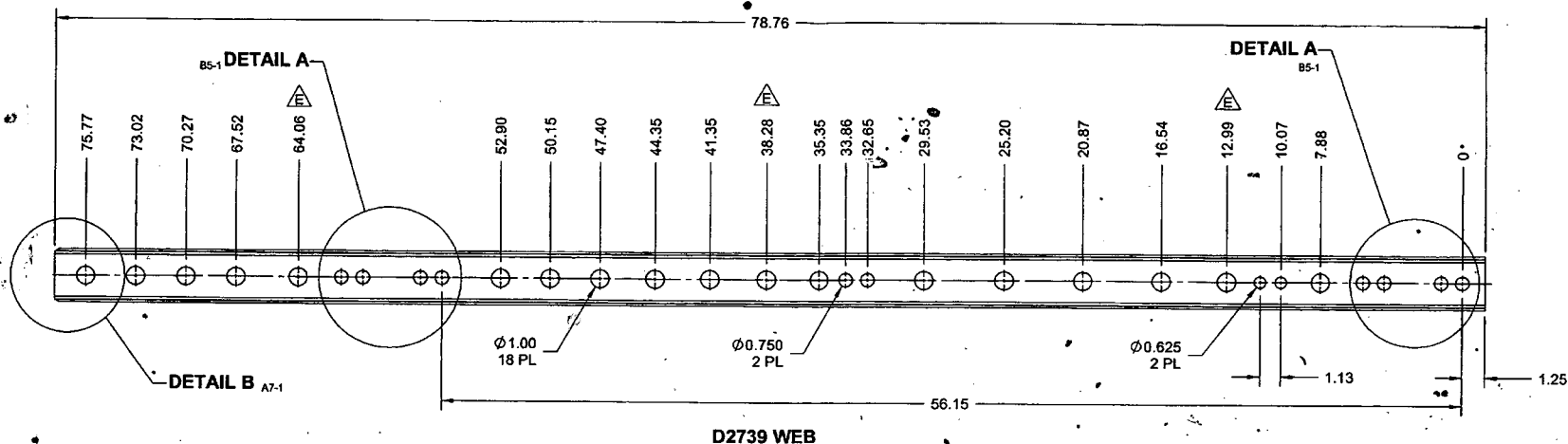
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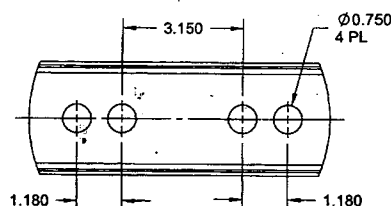
90684

24

10



DETAIL B
SCALE 3X C7-1



DETAIL A
SCALE 3X D7-1, D2-1

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1). ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D2739	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
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